

Date: Thursday, 2/21/2008 9:26:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 37570	
Estimate Number : 10519	
P.O. Number :	Part Number : D2855
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D2855 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 35972	Material :
Written By : <u>19080221</u>	Due Date : 3/10/2008 Qty: 30 Um: Each
Checked & Approved By : <u>19080221</u>	
Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5768C208/02/21

Cast per Dwg D2855

Material Release Note Required

(30)

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)
 CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

1908/03/03(30)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

1908/03/03 (30)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

1908/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/04 (430)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/03/04 (30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

m-l

08/03/04

(30X)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	ALS7-1032-225	Insert	M100489
	or AKS7-1032-225		
	or ALS4-1032-225		
	or AKS4-1032-225		

M100489

m-l 08/03/04

(30X)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

m-l

08/03/04

(30X)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/04 (430)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP 22

m-l 08/03/04

(30X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DD Date: 06/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37570

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/05

Job Completion



2008/3/04

(30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

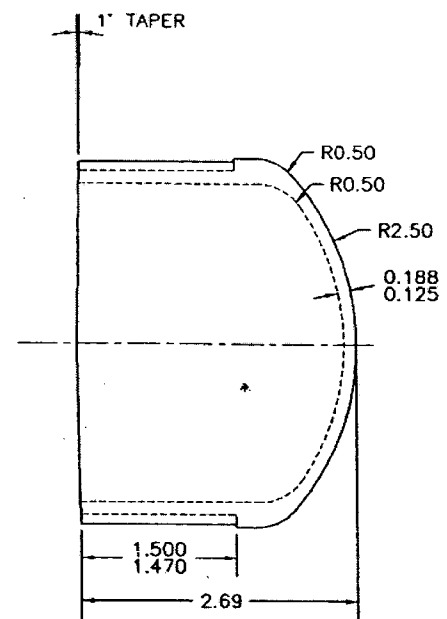
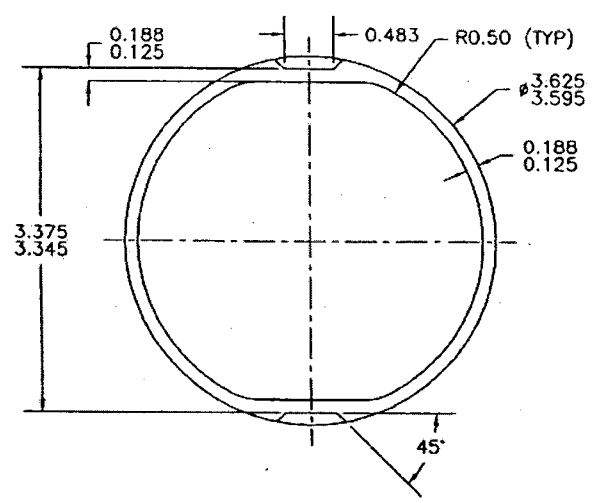
NOTE: Date & initial all entries



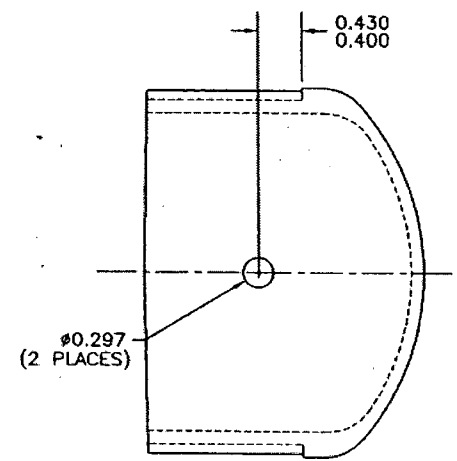
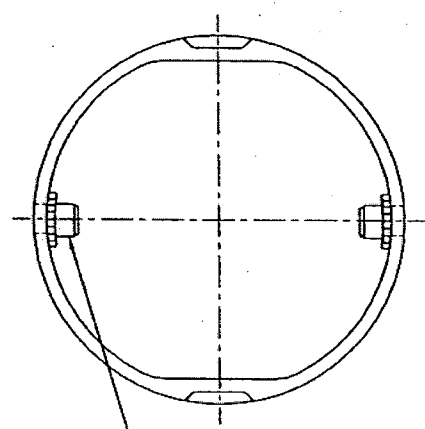
DESIGN	#1	DRAWN BY	#1	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	SC	APPROVED	AE	DRAWING NO. D2855	SHEET 1 OF 1
DATE	98.12.12	TITLE	CAP	SCALE	NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)			

RELEASED
98.12.14 DS

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 37570
WORK ORDER

7CERIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **27/02/2008** Slip No. **32417**

Hawksbury, ON, K6A 1K7

Votre No. Commande **00005768**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
30	D 2855 CAP	Z098046	A356.2	ingot#850156

Analyse
Analysis (as in ingot)

(Si)	7.00%	(Al)	balance
(Fe)	0.08%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.40%		
(Zn)	<0.01%		
(Ti)	0.18%		

Donne
Yield :

Résistance a la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

%

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :
Par/Per :

Coc-100